

# Work Order ID 93204

November-15-12 9:22:59 AM

**\*93204\***

Page 1

Item ID: D2932-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle LH Out, 206

Start Date: 11/15/12 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 12-11-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>   |                      |         |        |              |               |               |                  |                |
| D2932                          | Rev C   |                      |         |        |              |               |               |                  |                |
| 100                            | HAAS CNC VERTICAL MACHINING #1  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   |   |                      |         |        |              |               |               |                  |                |
| HAAS 1                         | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| HAAS CNC vertical machine #1   | Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per |                      |         |        |              |               |               |                  |                |
| 110                            | CONVENTIONAL MILLING MACHINE  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Mill Conv                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Conventional Milling Machine   | Machine Keyway and inspect per attached dimension sheet   |                      |         |        |              |               |               |                  |                |
| 120                            | QC1- Inspect dimensions to dimension sheet  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

PO 13/01/09 6 0

PO 13/01/09 6 0

PO 13/01/09 6 0

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |      |      |     |   |                      |   |                |              |              |  |  |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |      |      |     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                |              |              |  |  |
| <b>Root Cause</b>  | Date | Step | Qty | Description of work order update<br>or Non-conformance  | Initial<br>Chief Eng | Action<br>Description   | Sign &<br>Date | Verification | QC Inspector |  |  |
| Doc/Data <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Equip/Tooling <input type="checkbox"/>                       |      |      |     |   |                      |   |                |              |              |  |  |
| Operator <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Material <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Setup <input type="checkbox"/>                               |      |      |     |   |                      |   |                |              |              |  |  |
| Other <input type="checkbox"/>                               |      |      |     |   |                      |   |                |              |              |  |  |
| Process <input type="checkbox"/>                             |      |      |     |   |                      |   |                |              |              |  |  |
| Supplier <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Training <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Unapproved <input type="checkbox"/>                          |      |      |     |   |                      |   |                |              |              |  |  |

| FAULT CATEGORY   |  |  |   |  |  |   |  |  |   |  |  |
|--|--|--|---|--|--|---|--|--|---|--|--|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped.<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |  |  | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |  |  | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions |  |  | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |  |  |

# Work Order ID 93204

November-15-12 9:22:59 AM

**\*93204\***

Page 2

Item ID: D2932-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle LH Out, 206

Start Date: 11/15/12 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                     | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp   |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------|
| 130                            | QC8- Inspect parts - second check            | 0.00                 |         |        |              |               |               |                  |                  |
| <b>*130*</b>                   |  |                      |         |        |              |               |               |                  |                  |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  | DAS<br>08<br>8-8 |
| Quality Control                |  |                      |         |        |              |               |               |                  |                  |
| 140                            | Chemical Conversion Coat per QSI005 4.1      | 0.00                 |         |        |              |               |               |                  |                  |
| <b>*140*</b>                   |  |                      |         |        |              |               |               |                  |                  |
| HandFinish                     | Memo   | 0.00                 |         |        |              |               |               |                  |                  |
| Hand Finishing                 |  |                      |         |        |              |               |               |                  |                  |
| 150                            | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00                 |         |        |              |               |               |                  |                  |
| <b>*150*</b>                   |  |                      |         |        |              |               |               |                  |                  |
| Powdercoat                     | Memo   | 0.00                 |         |        |              |               |               |                  |                  |
| Powder Coating                 |  |                      |         |        |              |               |               |                  |                  |
|                                | START TIME: 1:55                             |                      |         |        |              |               |               |                  |                  |
|                                | FINISH TIME: 2:25                            |                      |         |        |              |               |               |                  |                  |

B.A 13/01/09

6 0

DAS  
08  
8-8

6 0 13-1-10.

6 0 13-1-14.

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |      |      |   |   |                      |   |                |   |              |  |  |
|--|------|------|---|---|----------------------|---|----------------|---|--------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____   |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                |   |              |  |  |
| <b>Root Cause</b>  | Date | Step | Qty   | Description of work order update<br>or Non-conformance  | Initial<br>Chief Eng | Action<br>Description   | Sign &<br>Date | Verification  | QC Inspector |  |  |
| Doc/Data <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Equip/Tooling <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Operator <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Material <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Setup <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Other <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Process <input type="checkbox"/>   |      |      |   |   |                      |   |                |   |              |  |  |
| Supplier <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Training <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| Unapproved <input type="checkbox"/>  |      |      |   |   |                      |   |                |   |              |  |  |
| <b>FAULT CATEGORY</b>  |      |      |   |   |                      |   |                |   |              |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped.<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                      | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |                | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |              |  |  |

# Work Order ID 93204

\*93204\*

Page 3

November-15-12 9:22:59 AM

Item ID: D2932-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle LH Out, 206

Start Date: 11/15/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160                            | QC3- Inspect Part Finish                    | 0.00                 |         |        |              |               |               |                  |                |
| *160*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 170                            | Identify as per dwg & Stock Location: 81407 | 0.00                 |         |        |              |               |               |                  |                |
| *170*                          |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 180                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| *180*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

low of M u l a l c u

low 13-01-15

13/1/17

13-01-15

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |             |             |   |   |                          |   |                        |                     |   |  |  |
|---|-------------|-------------|---|---|--------------------------|---|------------------------|---------------------|---|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |             |             |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                          | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                        |                     |   |  |  |
| <b>Root Cause</b>   | <b>Date</b> | <b>Step</b> | <b>Qty</b>  | <b>Description of work order update or Non-conformance</b>  | <b>Initial Chief Eng</b> | <b>Action Description</b>   | <b>Sign &amp; Date</b> | <b>Verification</b> | <b>QC Inspector</b>   |  |  |
| Doc/Data <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Equip/Tooling <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Operator <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Material <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Setup <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Other <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Process <input type="checkbox"/>  |             |             |   |   |                          |   |                        |                     |   |  |  |
| Supplier <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Training <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| Unapproved <input type="checkbox"/>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| <b>FAULT CATEGORY</b>   |             |             |   |   |                          |   |                        |                     |   |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |             |             | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                          | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |                        |                     | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |  |  |

# Picklist Print

November-15-12 9:22:59 AM

Page 1

Work Order ID: 93204

Parent Item: D2932-1

Parent Item Name: Saddle LH Out, 206

Start Date: 11/15/12

Required Date: 11/30/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev, (mpp 2069)EC  
IPP Rev:C As per Rev C 07-03-19 JLM

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003<br>Saddle Billet, 7075 |                        | Manufactured  | No          |                     |                  | 100             | Each               | 20.0000        | 1           | 6            |               |                |        |

Location Loc Qty Loc Code

MAT040

19

73775

2

73780

7

78599

10

80765

0

MAT044

1

73769

1

91238

6

FK 12/01/06

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |      |      |     |   |                   |   |             |              |              |  |  |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |      |      |     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |             |              |              |  |  |
| Root Cause   | Date | Step | Qty | Description of work order update or Non-conformance   | Initial Chief Eng | Action Description  | Sign & Date | Verification | QC Inspector |  |  |
| Doc/Data <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Equip/Tooling <input type="checkbox"/>                       |      |      |     |   |                   |   |             |              |              |  |  |
| Operator <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Material <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Setup <input type="checkbox"/>                               |      |      |     |   |                   |   |             |              |              |  |  |
| Other <input type="checkbox"/>                               |      |      |     |   |                   |   |             |              |              |  |  |
| Process <input type="checkbox"/>                             |      |      |     |   |                   |   |             |              |              |  |  |
| Supplier <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Training <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Unapproved <input type="checkbox"/>                          |      |      |     |   |                   |   |             |              |              |  |  |

| FAULT CATEGORY  |   |   |  |   |
|---|---|---|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |



|   |  |                             |
|---|--|-----------------------------|
| <b>DART AEROSPACE LTD</b>                           |  | <b>Work Order:</b> 93204    |
| <b>Description:</b> 206 Saddle, Outboard, Left side |  | <b>Part Number:</b> D2932-1 |
| <b>Inspection Dwg:</b> D2932 Rev. C                 |  | <b>Page 1 of 1</b>          |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.100 | 0.140 |                | .104                       | .110  | .104  | .106  |    |      |
| B             | 0.100 | 0.140 |                | .107                       | .116  | .114  | .109  |    |      |
| C             | 0.100 | 0.140 |                | .115                       | .117  | .114  | .115  |    |      |
| D             | 0.210 | 0.230 |                | .220                       | .220  | .220  | .220  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| H             | 0.510 | 0.515 |                | .514                       | .514  | .514  | .514  |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.577 | 1.577 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| K             | 0.257 | 0.262 |                | .258                       | .258  | .258  | .258  |    |      |
| L             | 0.312 | 0.317 |                | .314                       | .314  | .314  | .314  |    |      |
| M             | 0.235 | 0.240 |                | .239                       | .239  | .239  | .239  |    |      |
| N             | 0.100 | 0.140 |                | .120                       | .120  | .120  | .120  |    |      |
| O             | 0.540 | 0.560 |                | .549                       | .550  | .554  | .549  |    |      |
| P             | 0.490 | 0.510 |                | .499                       | .497  | .501  | .497  |    |      |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 | 3.720 | 3.720 |    |      |
| R             | 2.470 | 2.510 |                | 2.488                      | 2.488 | 2.489 | 2.488 |    |      |
| S             | 0.240 | 0.270 |                | .253                       | .249  | .249  | .248  |    |      |
| T             | 0.100 | 0.180 |                | .140                       | .140  | .140  | .140  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.367 |    |      |
| W             | 0.316 | 0.321 |                | .316                       | .316  | .316  | .316  |    |      |
| X             | 1.125 | 1.145 |                | 1.133                      | 1.135 | 1.136 | 1.136 |    |      |
| Y             | 1.565 | 1.585 |                | 1.573                      | 1.573 | 1.575 | 1.575 |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                 |
|-----------------|
| Measured by: PD |
| Date: 13/01/09  |

|                 |      |
|-----------------|------|
| Audited by: H.A | JAS  |
| Date: 13/01/09  | 08   |
|                 | 7-89 |

| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                    | KJ/JLM     |          |

|   |                     |             |
|---|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 93204       |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> | D2932-1     |
| <b>Inspection Dwg:</b> D2932 Rev. C                 |                     | Page 1 of 1 |

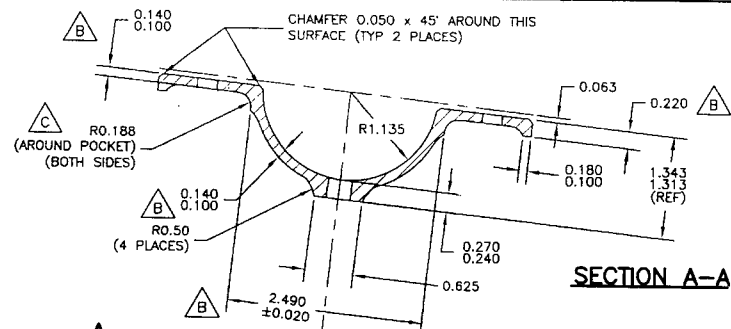
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |   |   |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3 | 4 | By | Date |
| A             | 0.100 | 0.140 |                | .106                       | .117  |   |   |    |      |
| B             | 0.100 | 0.140 |                | .111                       | .117  |   |   |    |      |
| C             | 0.100 | 0.140 |                | .116                       | .122  |   |   |    |      |
| D             | 0.210 | 0.230 |                | .219                       | .219  |   |   |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| H             | 0.510 | 0.515 |                | .514                       | .514  |   |   |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 |   |   |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| K             | 0.257 | 0.262 |                | .258                       | .258  |   |   |    |      |
| L             | 0.312 | 0.317 |                | .314                       | .314  |   |   |    |      |
| M             | 0.235 | 0.240 |                | .238                       | .238  |   |   |    |      |
| N             | 0.100 | 0.140 |                | .119                       | .119  |   |   |    |      |
| O             | 0.540 | 0.560 |                | .549                       | .548  |   |   |    |      |
| P             | 0.490 | 0.510 |                | .495                       | .500  |   |   |    |      |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 |   |   |    |      |
| R             | 2.470 | 2.510 |                | 2.488                      | 2.488 |   |   |    |      |
| S             | 0.240 | 0.270 |                | .247                       | .247  |   |   |    |      |
| T             | 0.100 | 0.180 |                | .140                       | .140  |   |   |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 |   |   |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 |   |   |    |      |
| W             | 0.316 | 0.321 |                | .316                       | .316  |   |   |    |      |
| X             | 1.125 | 1.145 |                | 1.136                      | 1.135 |   |   |    |      |
| Y             | 1.565 | 1.585 |                | 1.575                      | 1.574 |   |   |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188  |   |   |    |      |
| AA            |       |       |                |                            |       |   |   |    |      |
| AB            |       |       |                |                            |       |   |   |    |      |
| AC            |       |       |                |                            |       |   |   |    |      |
| AD            |       |       |                |                            |       |   |   |    |      |
| AE            |       |       |                |                            |       |   |   |    |      |
| AF            |       |       |                |                            |       |   |   |    |      |
| AG            |       |       |                |                            |       |   |   |    |      |
| AH            |       |       |                |                            |       |   |   |    |      |
| Accept/Reject |       |       |                |                            |       |   |   |    |      |

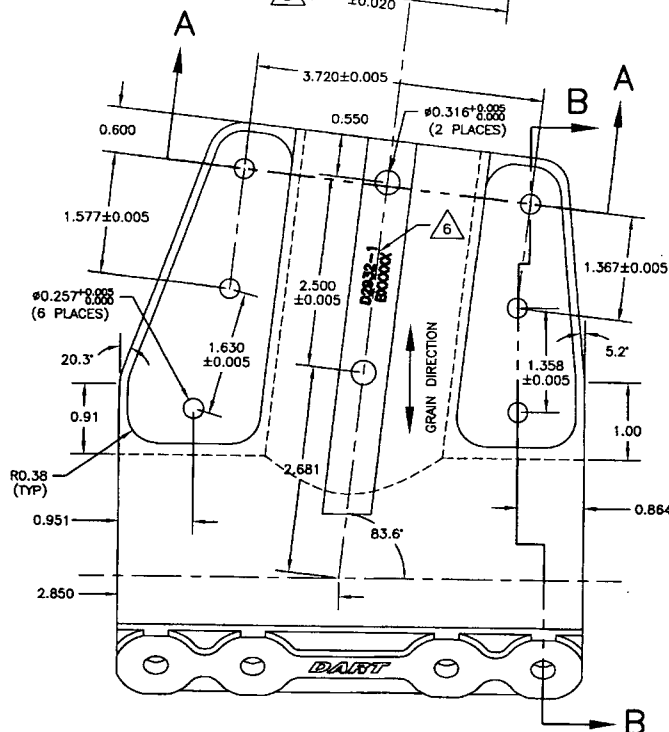
|                 |
|-----------------|
| Measured by: PD |
| Date:           |

|                 |
|-----------------|
| Audited by: DAS |
| Date: 13/01/09  |

| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                    | KJ/JLM     |          |

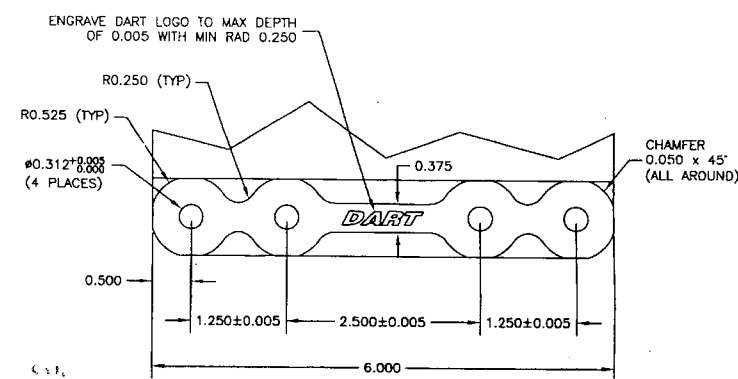
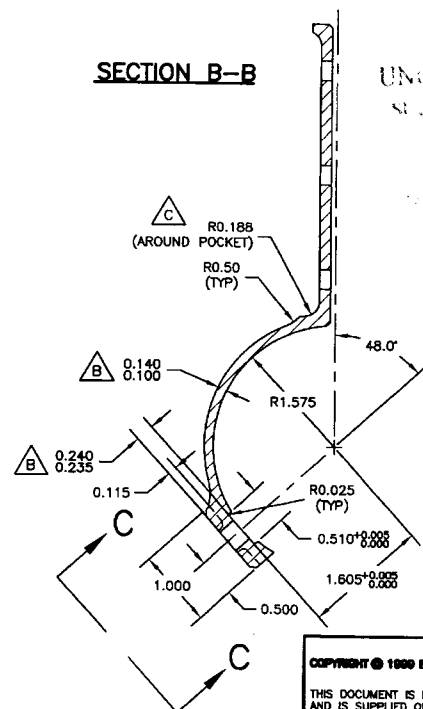


SECTION A-A



RELEASED  
07-02-12

SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

93204  
MLG  
12-11-16

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

|         |          |                               |
|---------|----------|-------------------------------|
| C       | 06.11.09 | R0.188 WAS R0.30 TO R0.25     |
| B       | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A       | 99.10.29 | NEW ISSUE                     |
| DESIGN  | 4        | DRAWN BY CB                   |
| CHECKED | PH       | APPROVED                      |
| DATE    | 06.11.09 | TITLE                         |
|         |          | SADDLE OUTSIDE                |

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**DART** DART AEROSPACE USA, INC.  
BELLEVUE, WA

REV. C  
SHEET 1 OF 1

SCALE  
2:3